

**Work Order ID 60006**

Tuesday, June 22, 2010 2:40:18 PM



Page 1

Item ID: D3908-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Aft

Start Date: 6/23/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/28/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 10-6-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3908

C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

50/06/23 (4)

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg  
TRIM RIVETS 1.185" LONG

50/06/23 (4)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/23

(4)

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Accept



Setup Start



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Stop



Item Name: Crosstube Lug Assembly, Aft

Start Date: 6/23/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/28/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location 476

0.00



Packaging

Memo

0.00

Packaging

10-6-83 40 SF

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/24 JF  
CZ10/06/24

# Picklist Print

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Page 1

Work Order ID: 60006

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 6/23/2010

Required Date: 7/28/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC  
As per Rev B 10-04-06 VERIFIED BY:DD  
10.05.27 DD verf:EC  
10.05.28 DD verf:EC  
IPP REV B:  
IPP Rev:C as per PC1  
IPP Rev:D per ECN10-581

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2690-6



Lanyard Assembly

Manufactured

No

100

Each

40.0000

1

4



*EP 5/10/06/23*

Location

Loc Qty

Loc Code

ST020

30

59960

30

ST021

10

58375

10

*4*

D3908-1



Lug Plate, Aft Crosstube

Manufactured

No

100

Each

13.0000

2

8



*EP 5/10/06/23*  
*B60035 (6x)*

Location

Loc Qty

Loc Code

ST094

2

59343

2

ST095

11

58344

11

*2*

D3908-3



Stud Receiver, Lower

Manufactured

No

100

Each

11.0000

1

4



*EP 5/10/06/23*

Location

Loc Qty

Loc Code

ST095

11

57816

2

58849

1

59453

8

*3*

*1*

# Picklist Print

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Work Order ID: 60006

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 6/23/2010

Required Date: 7/28/2010

Start Qty: 4.00

Required Qty: 4.00

D3908-5  
  
 Eyebolt Stud

Manufactured No

100 Each

19.0000

1



4

*Ep 5/10/06/23*

Location

Loc Qty

Loc Code

GA

1

57428

1

ST095

18

58850

8

59670

10

4

D3910-1  
  
 Crosstube Lug

Manufactured No

100 Each

39.0000

1



4

*Ep 5/10/06/23*

Location

Loc Qty

Loc Code

st507

39

58341

9

59349

24

59708

6

4

D4091-1  
  
 Mounting Lug

Manufactured No

100 Each

8.0000

1



4

*Ep 5/10/06/23*

Location

Loc Qty

Loc Code

ST460

8

59239

8

4

AN3C12A  
  
 Bolts

Purchased No

100 Each

96.0000

2



8

*Ep 5/10/06/23*

Location

Loc Qty

Loc Code

ST351

96

112314

46

114761

50

8

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Shop Packet Print

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# Picklist Print

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Work Order ID: 60006

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 6/23/2010

Required Date: 7/28/2010

Start Qty: 4.00

Required Qty: 4.00

AN4C13A Purchased No

100 Each

110.0000

1

4



BOLT



*EP 10/06/23*

Location

Loc Qty

Loc Code

ST357

110

113359

4

114108

6

114442

50

114615

50

*1*  
*4*

MS17984-C413 Purchased No

100 Each

39.0000

1

4



PIN, QUICK RELEASE



*EP 10/06/23*

Location

Loc Qty

Loc Code

ST297

4

114340

4

ST314

35

114523

1

114774

14

114886

20

*4*

MS20615-4M20 Purchased No

100 Each

200.0000

6

24



RIVET



*EP 10/06/23*

Location

Loc Qty

Loc Code

ST323

200

114808

200

*M1145106 (16x)*

*M114808 (8x)*

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Work Order ID: 60006

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 6/23/2010

Required Date: 7/28/2010

Start Qty: 4.00

Required Qty: 4.00

MS21043-3 Purchased No

100 Each

3,223.000 2



Nut



8  
E 5/0/06/23

Location

Loc Qty

Loc Code

FG	76
103691	76
ST301	3147
112314	3147

MS21043-4 Purchased No

100 Each

1,360.000 1



Nut



8  
E 5/0/06/23

Location

Loc Qty

Loc Code

FG	40
104603	40
ST301	1320
112492	25
113069	8
114348	487
114523	500
114784	300

NAS1149C0332R Purchased No

100 Each

5,196.000 4



Washer



16  
E 5/0/06/23

Location

Loc Qty

Loc Code

ST297	5196
113524	10
113737	150
114341	36
115000	5000

16

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Page 5

Work Order ID: 60006



Parent Item: D3908-041



Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 6/23/2010

Required Date: 7/28/2010

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0432R

Purchased

No

100

Each

744.0000

2

8



Washer



*EPB/OG/K3*

8

Location

Loc Qty

Loc Code

ST297

744

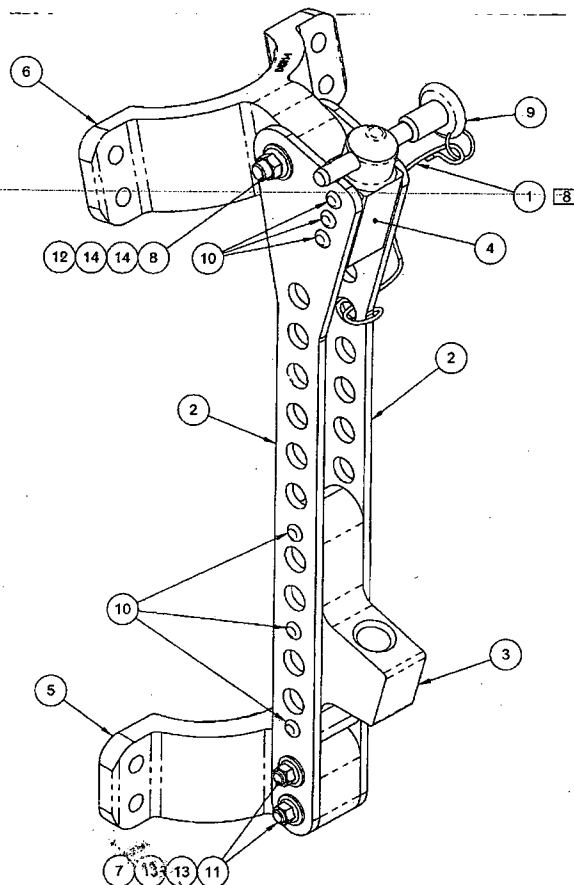
114292

144

114742

600

ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20815-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



**D3908-041 X-TUBE LUG ASSY (AFT)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

**RELEASED**  
2010-05-28  
W

C	REDESIGNED ITEM #2; ITEM#6 REPLACES QTY 1 ITEM#5; QTY 2 FOR ITEMS #7 & 11 WAS QTY 4, QTY 8 FOR ITEM #13 WAS 4, ADDED ITEMS #8, 12 & 14	MB	10.05.27
B	BOM: D3908-5 REPLACED WITH D3908-5, QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 5: ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.05.27		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3908</b> TITLE <b>X-TUBE LUG ASSY (AFT)</b> SCALE <b>NTS</b> REV. C SHEET 1 OF 5 COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

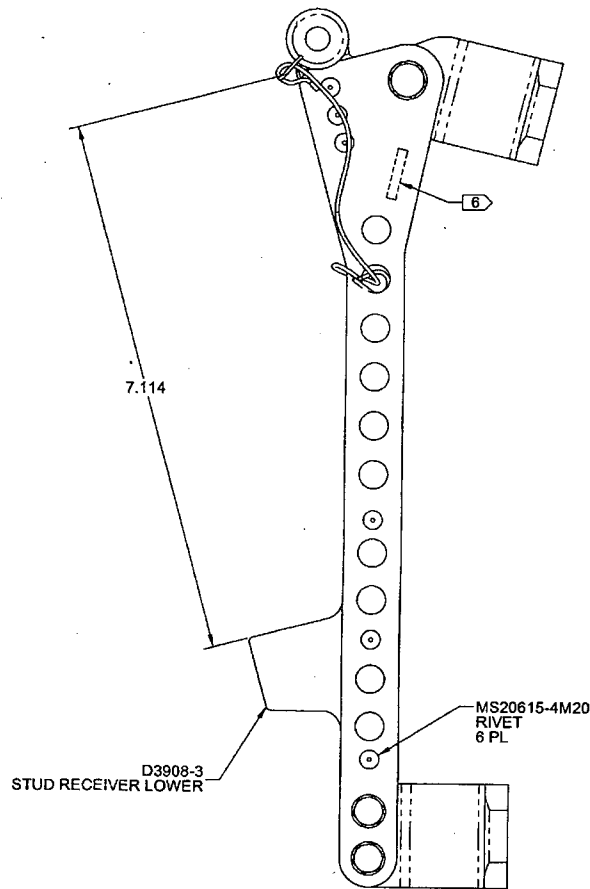
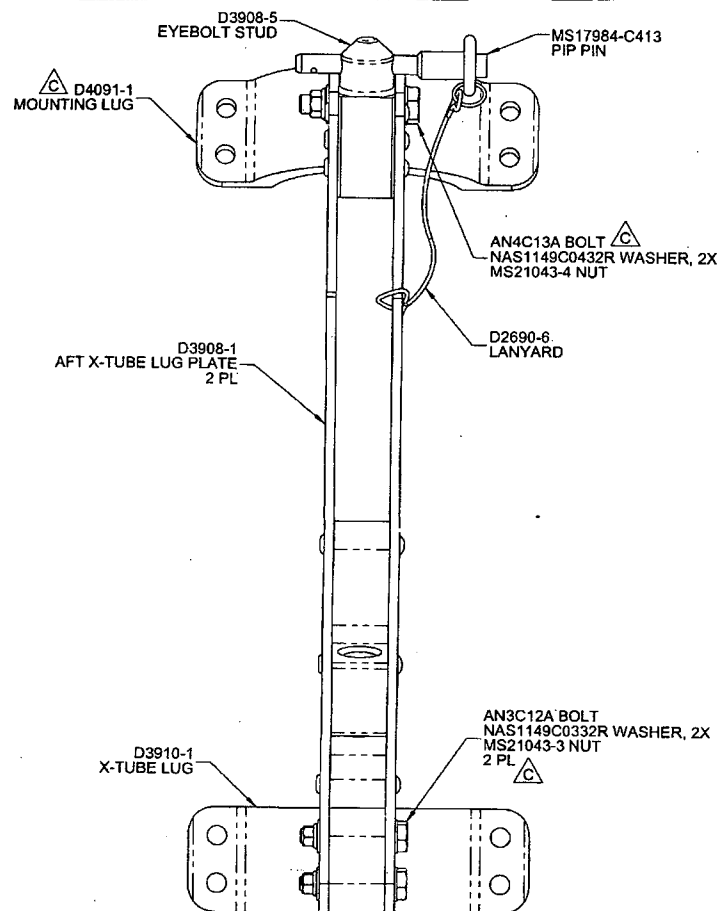
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



#60006

**RELEASED**  
2010-05-28  
JND

**D3908-041 X-TUBE LUG ASSY (AFT)**

DESIGN	JFH	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

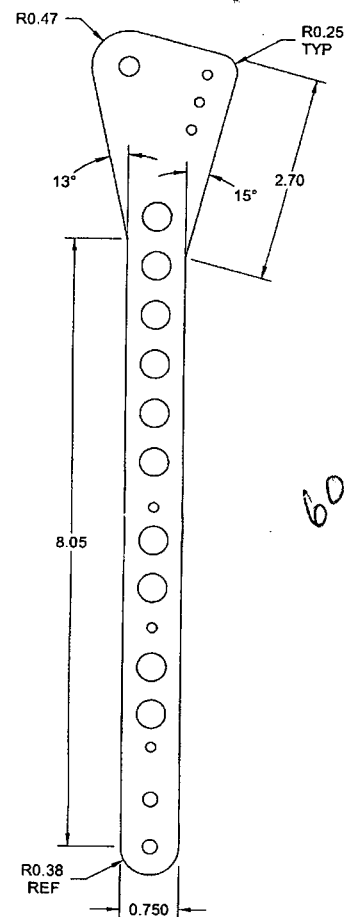
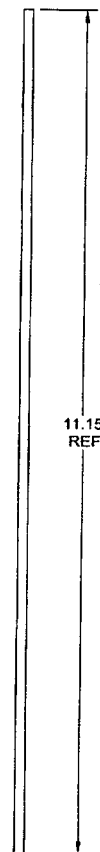
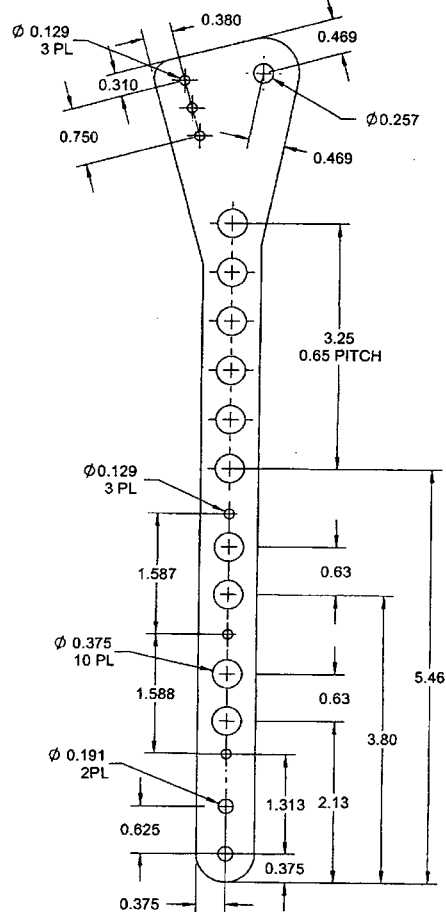
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



60006

RELEASED  
2010-05-28  
MND

# NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.31 lbs

## D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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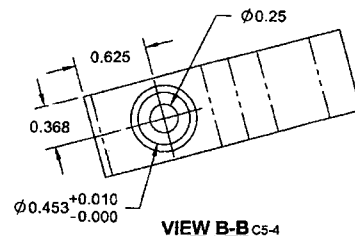
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

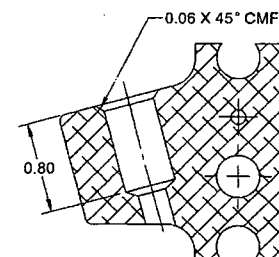
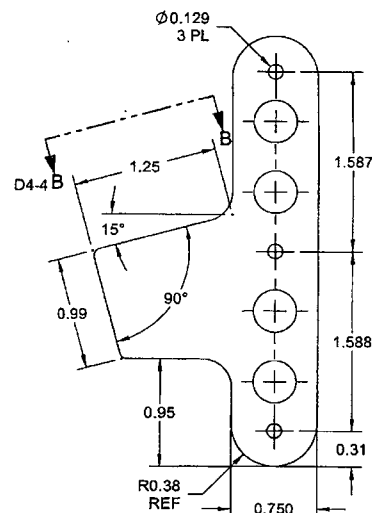
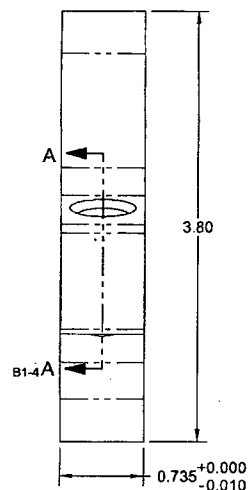
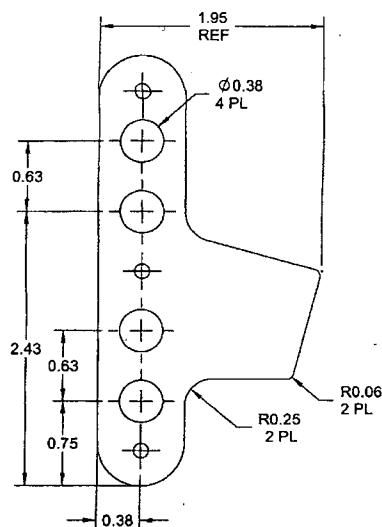
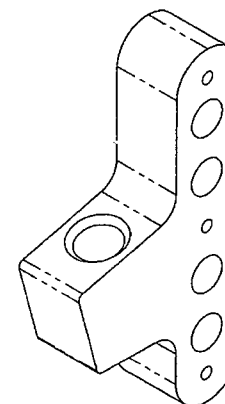
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



60006



SECTION A-A B6-4

# **D3908-3 STUD RECEIVER LOWER**

## **NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

**RELEASED**  
2010-05-28

DESIGN	JFH	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3908</b>	REV. C
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE <b>X-TUBE LUG ASSY (AFT)</b>	SCALE
DE APPR.			NTS
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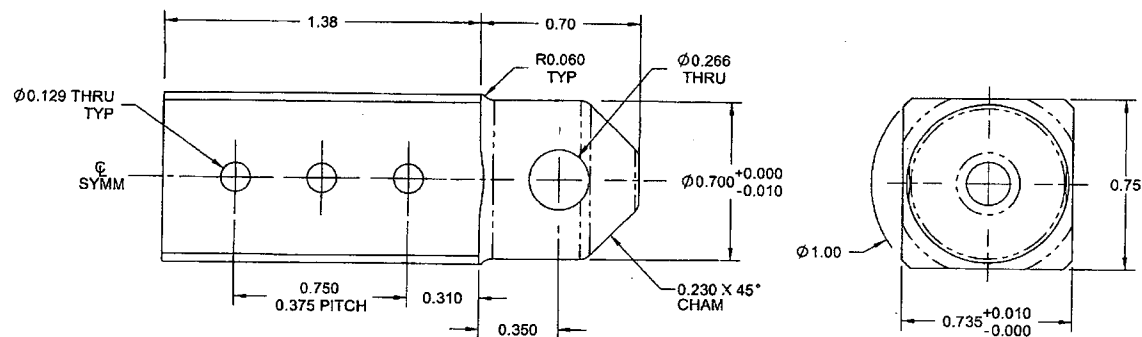
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3908-5 EYEBOLT STUD**

**RELEASED**  
2010-05-28  
MD

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	JFH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D3908	REV. C
CHECKED			SHEET 5 OF 5
MFG. APPR.		TITLE X-TUBE LUG ASSY (AFT)	SCALE NTS
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DATE	10.05.27		



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries